

Date: Wednesday, 06/06/2007 2:45:08 PM  
User: Linda Lacelle

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARSHOE  
Job Number : 32818  
Estimate Number : 10611  
P.O. Number : N/A Part Number : D265611  
This Issue : 06/06/2007 S.O. No. : N/A Drawing Number : D2656 REV D  
Prsht Rev. : NC Project Number : N/A  
First Issue : N/A Type : PURCHASED PARTS Drawing Revision : D  
Previous Run : 32818 Material : N/A Due Date : 08/06/2007 Qty: 10 Um: Each  
Written By :  
Checked & Approved By :  
Comment : Est: D 02.10.24 Re-format KJ  
est rev E 07.06.06 waterjet EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S20GA 1010/1025/A21/6aA SHEET



Comment: Qty.: 0.8500 sf(s)/Unit Total : 8.5000 sf(s)  
1010/1025/A21/6aA SHEET

SAO 07/06/06

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
1-Cut as per Dwg D2656  
Dwg Rev: D  
Prog Rev: D

2-Deburr if necessary

SAO 07/06/06

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAO 07/06/06

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SAO 07/06/06

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326  
2-Form joggle as per Dwg D2656 using Jig DT8158 Identify as D2656-11

SAO 07/06/07

mf 07-06-07

Date: Wednesday, 06/06/2007 2:45:08 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 32818

Part Number: D265611

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07-06-07 (3)*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*m/01601*

*07/06/07 (13)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*U 07-06-07*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*FP-18*

*m-h 07/06/07*

*(13K)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07-06-07*

Job Completion



*U 07-06-07*

08/06

Date: Wednesday, 06/06/2007 2:00:02 PM  
User: Linda Lacelle

Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : WEARSHOE
<b>Job Number</b> : 32818	
<b>Estimate Number</b> : 10611	
<b>P.O. Number</b> :	<b>Part Number</b> : D265611
<b>This Issue</b> : 06/06/2007 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2656 REV D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : D
<b>Previous Run</b> :	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 08/06/2007 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est: D 02.10.24 Re-format KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: \_\_\_\_\_

Email or ship DXF file to vendor

Laser Cut per Dwg D2656 flat pattern D2656-11

Material release note required

2.0	D265611F	Wearplate
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**Comment:** Qty.: 1.0000 Each(s)/Unit    Total : 10.0000 Each(s)

Wearplate

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material release note is attached

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Inspect dimensions per template D2656-11T1

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 06/06/2007 2:00:02 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 32818

Part Number: D265611

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326

2-Form joggle as per Dwg D2656 using Jig DT8158 Identify as D2656-11

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per CSI 005 4.3

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

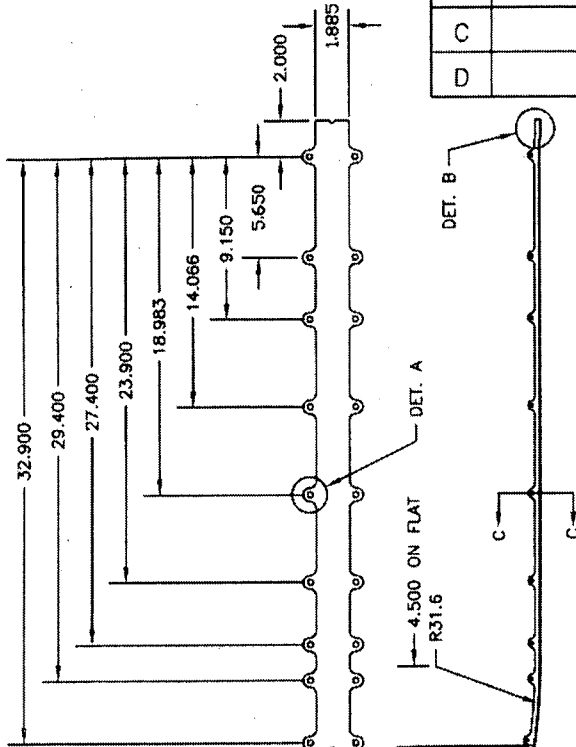
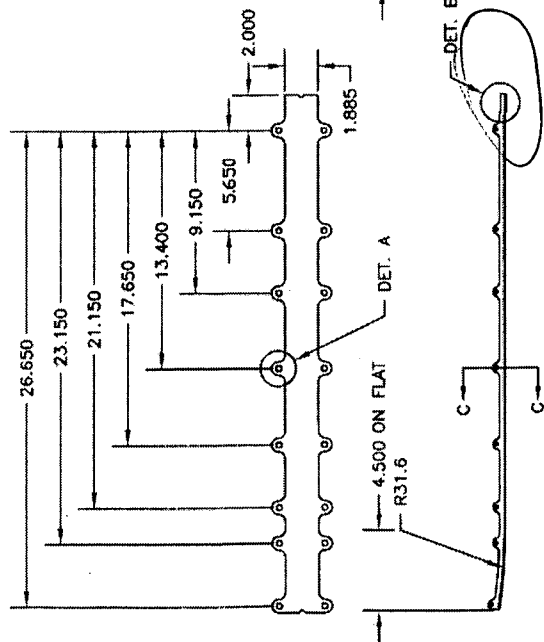
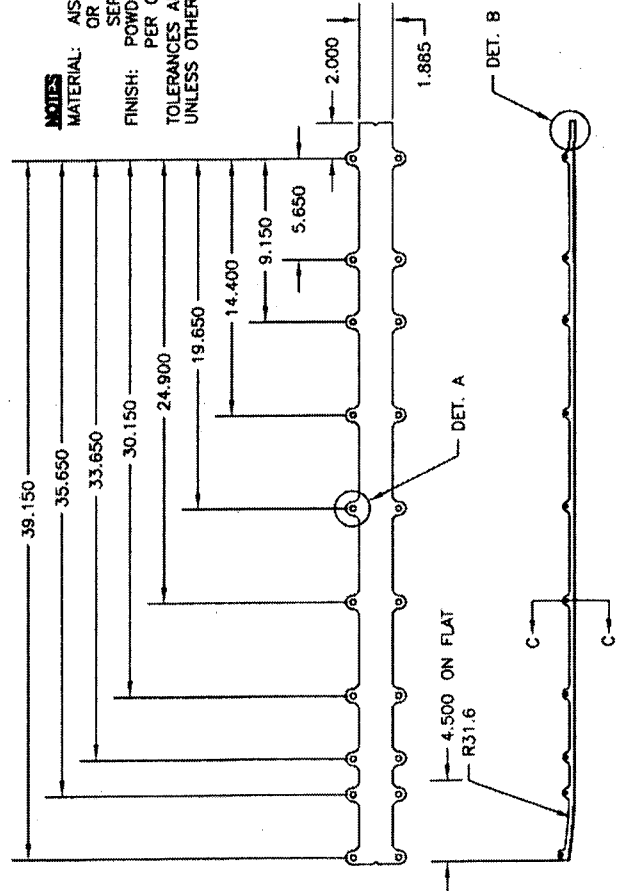
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN DS		DRAWN BY CP		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 		APPROVED 		DRAWING NO. D2656	REV. D SHEET 1 OF 4
DATE 05.08.17		TITLE WEARSHOE		SCALE 1:10	
A	97:03:25	NEW ISSUE			
B	97:06:02	CHANGED TABS			
C	97:06:26	R31.6 WAS R19.5			
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT			

**D2656-13****D2656-11****D2656-15**

**NOTES**  
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008  
OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)  
PER QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

RELEASED  
05.09.08

W/O 3288

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_



QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

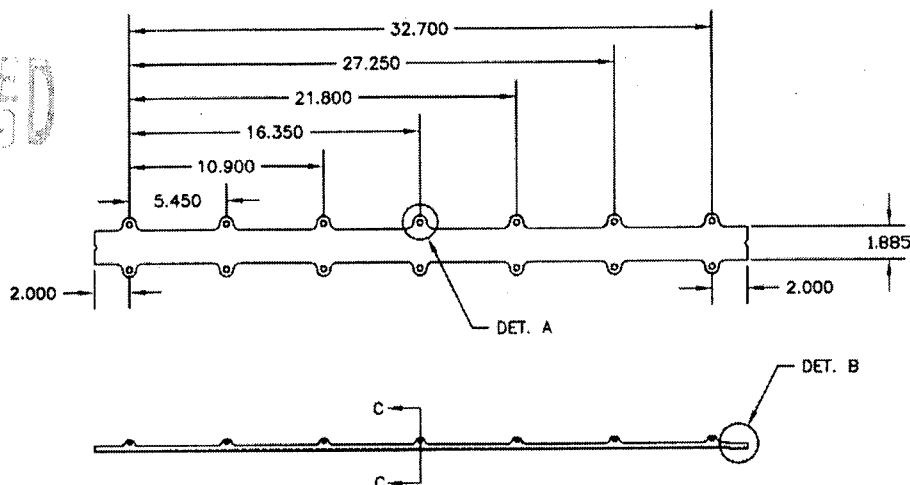




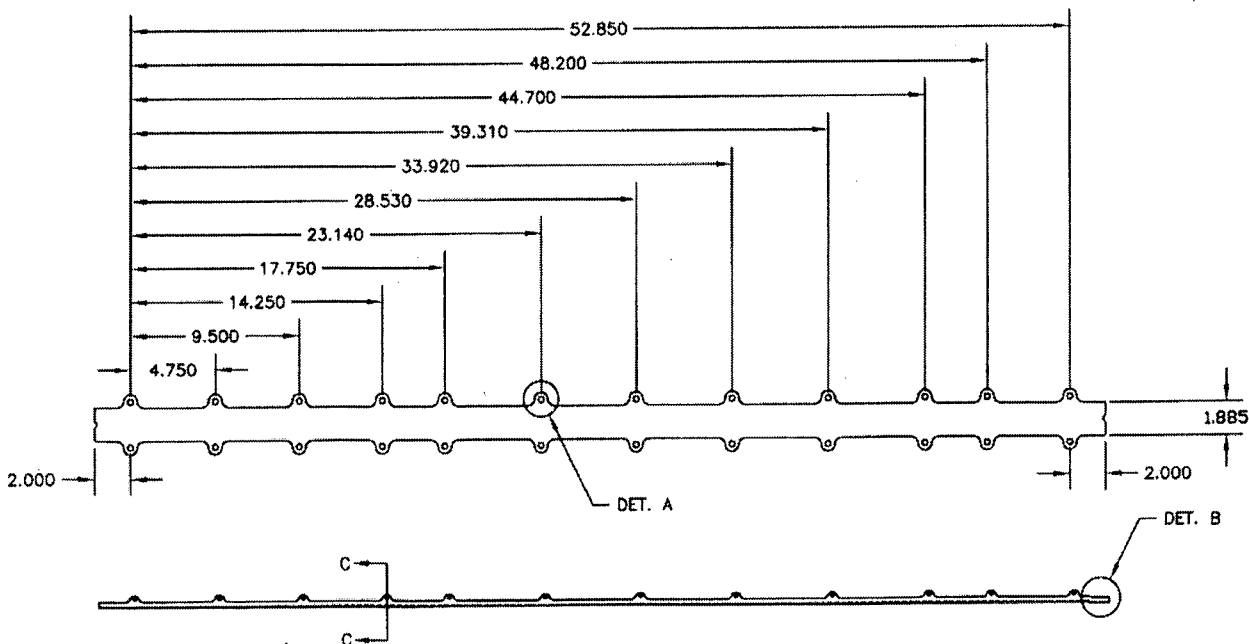
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				PORT HADLOCK, WA			
CHECKED		APPROVED		DRAWING NO.	REV. D		
				D2656	SHEET 2 OF 4		
DATE				TITLE	SCALE		
05.08.17				WEARSHOE	1:10		

RELEASED  
05.07.06

### D2656-21



### D2656-23



#### NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

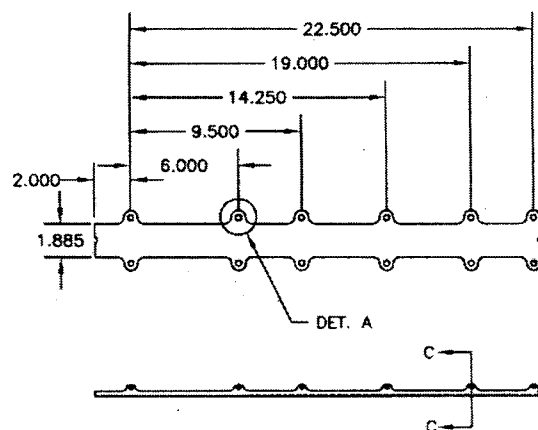
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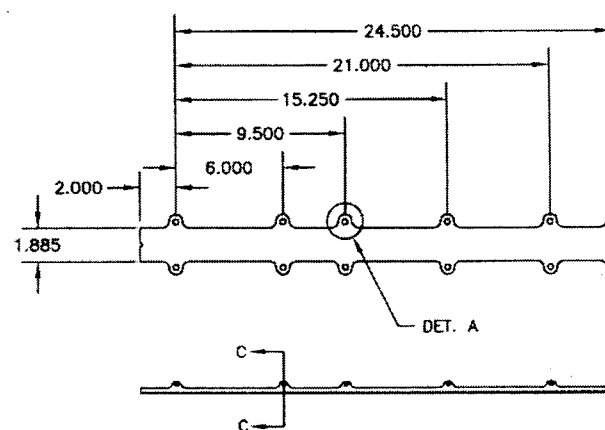
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.08.17	TITLE	D2656	WEARSHOE
				REVISION
				SHEET 3 OF 4
				SCALE
				1:10

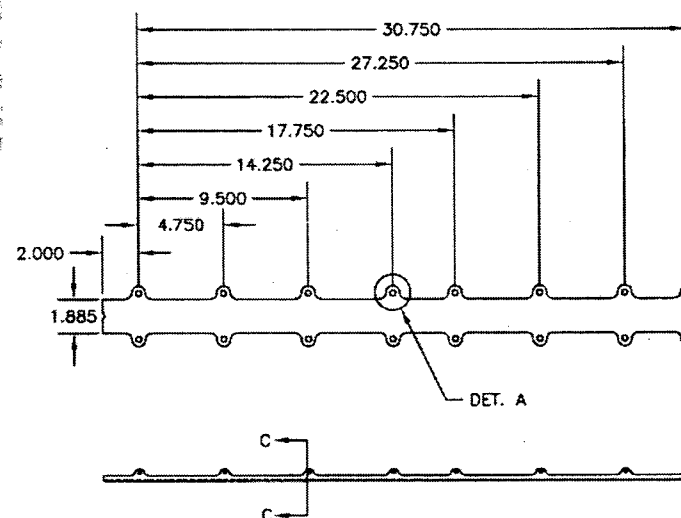
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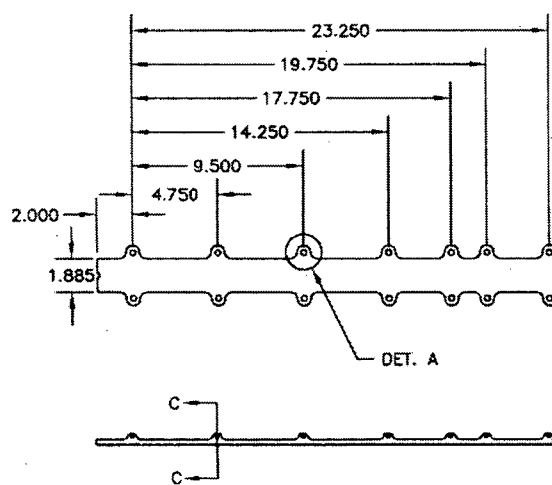
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**D2656-37**



**D2656-35**



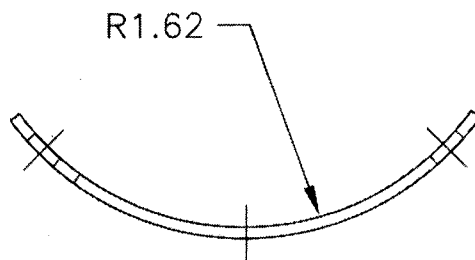
**NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
 SERIES STEEL, 20 GAUGE (0.040 THICK)  
 FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3  
 TOLERANCES ARE PER DART QSI 018  
 UNLESS OTHERWISE NOTED



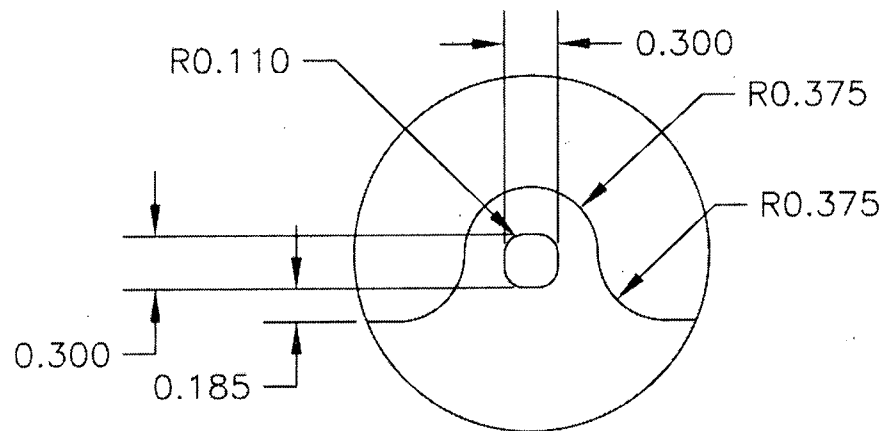
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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

### SECTION C-C

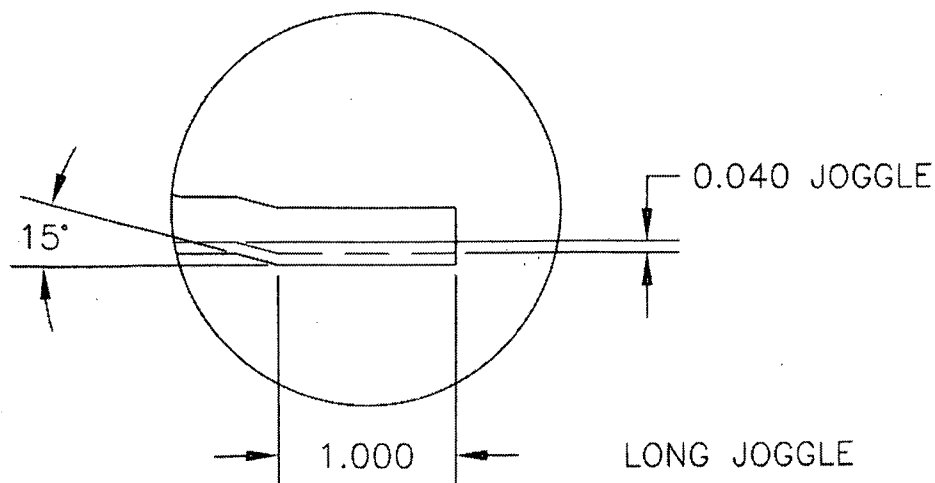


RELEASED  
05.09.06 *[Signature]*

### DETAIL A



### DETAIL B



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DART AEROSPACE LTD		Work Order: 32818
Description: WEARSHOE		Part Number: D2656-11
Inspection Dwg:	Rev: D	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 26.650	+/- 0.050	26.650	✓		M-T	
B 23.150	+/- 0.010	23.150	✓		M-T	
C 21.150	+/- 0.010	21.150	✓		M-T	
D 17.650	+/- 0.010	17.650	✓		M-T	
E 13.400	+/- 0.010	13.400	✓		M-T	
F 9.150	+/- 0.010	9.155	✓		Vern	
G 5.650	+/- 0.010	5.652	✓		Vern	
H 2.000	+/- 0.010	2.005	✓		Height gage	
I 1.885	+/- 0.010	1.894	✓		Vern	
J 0.300	+/- 0.010	0.300	✓		Vern	
K 0.300	+/- 0.010	0.295	✓		Vern	
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAM	Audited by: BC	Prototype Approval:	N/A
Date: 07/06/06	Date: 07.06.06	Date:	N/A
Rev	Date	Change	Revised by
		New Issue	KJ/RF
			Approved

*[Handwritten Signature]*

